

Date: Thursday, 3/2/2006 3:07:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB
 Job Number : 26027
 Estimate Number : 10195
 P.O. Number : N/A Part Number : D21741
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : D2174-1 REV. D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
 Previous Run : N/A Material : N/A
 Due Date : 3/25/2006 Qty: 40 Um: Each
 Written By : SRE COMMENT BELOW
 Checked & Approved By : 06.03.02
 Comment : Est C 04.06.09 Reformat KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Batch: M19059

ml 06/03/18 40

2.0 SHEAR SHEAR



Comment: SHEAR
 Cut blank: 12.75" x 4.83" Grain along 12.75"

ml 06/03/18 40

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA097 and Dwg D2174
 Stack of 10
 Identify as D2174-1

ml 06/03/18 40

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/18 40

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/03/18 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: SD Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

ml *08/03/22* 40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-23 40

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD *06:04:02*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06-04-05 40

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *220*

06/4/5 (40)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-04-05 (40)

Job Completion



06-04-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

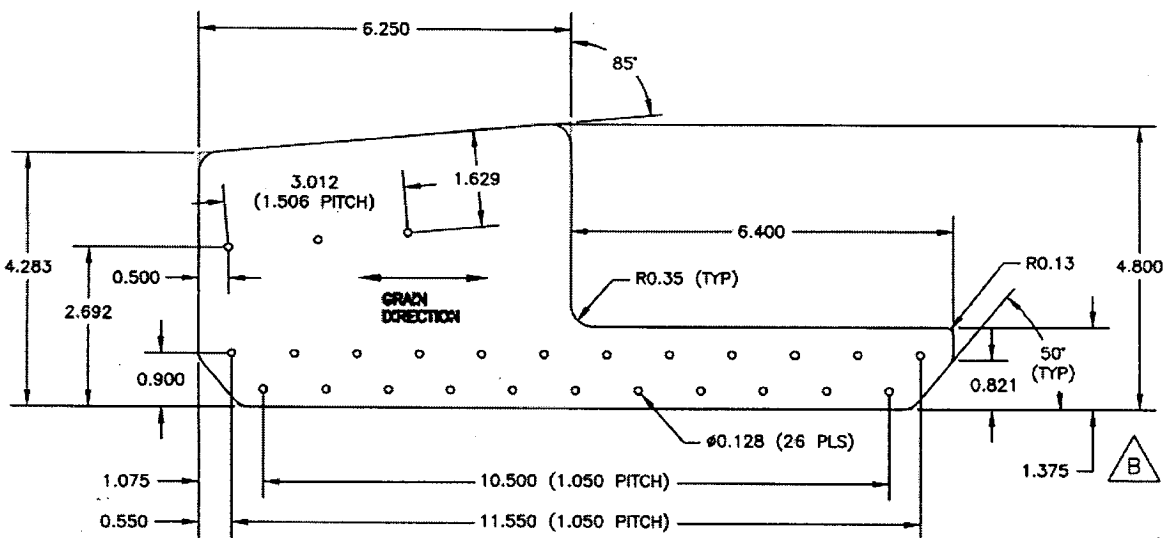
DESIGN	DRAWN BY	DRAWING NO.	REV. 0
1	1	D2174-1	

CHECKED	APPROVED	DATE	TITLE	SCALE
1	1	04.06.03	WEB	1:3

A	B	C	D
95.10.25	96.01.18	00.09.11	04.06.03

NEW ISSUE	RE-DRAWN CHANGE DIMENSION	UPDATE FINISH SPEC	RE-DESIGN
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RELEASED
04.06.03



D2174-1

NOTES:

- 1 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4 BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5 ALL DIMENSION ARE IN INCHES



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
CONTACT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26027

